

Work Order ID 61755

Wednesday, September 01, 2010 2:23:51 PM



Page 1

Item ID: D2232-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Hinge

Start Date: 9/1/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-9-01

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D2232	Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2232 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

304 .125

10-9-2

[Signature]

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-9-2

120

QC8- Inspect parts - second check

0.00



QC

Memo

SM-03

0.00

Quality Control

6

[Signature] 100503

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo
Debur

0.00

Small Fab

ala 8

140

0.00



Packaging

Identify as per dwg & Stock Location: LWA

Memo

0.00

Packaging

*****STOCK IN BASKET CELL*****

SAD

10-09-09

(6)

150

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/09/13 J

10-210
(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Wednesday, September 01, 2010 2:23:56 PM

Page 1

Work Order ID: 61755



Parent Item: D2232-3



Parent Item Name: Basket Hinge

Start Date: 9/1/2010

Required Date: 9/7/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP B 01.06.07 Now laser cut EC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	73.0423	0.0694	0.438316			



304/316 0.125 Sheet



1810-9-2

Location

Loc Qty

Loc Code

MAT

73.0423

114799

73.0423

114799

6

W/O:		WORK ORDER CHANGES					
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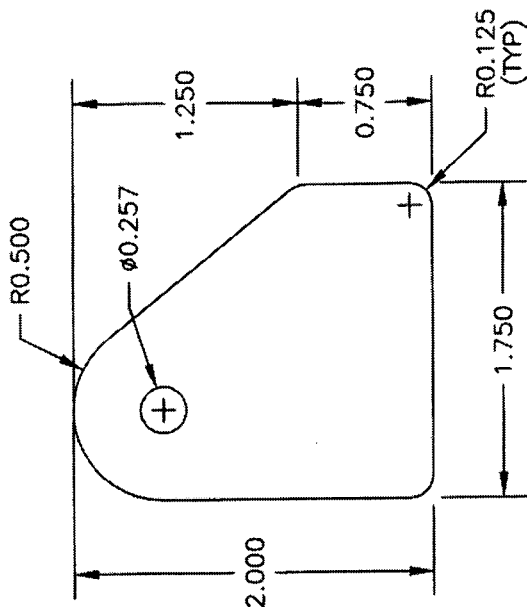
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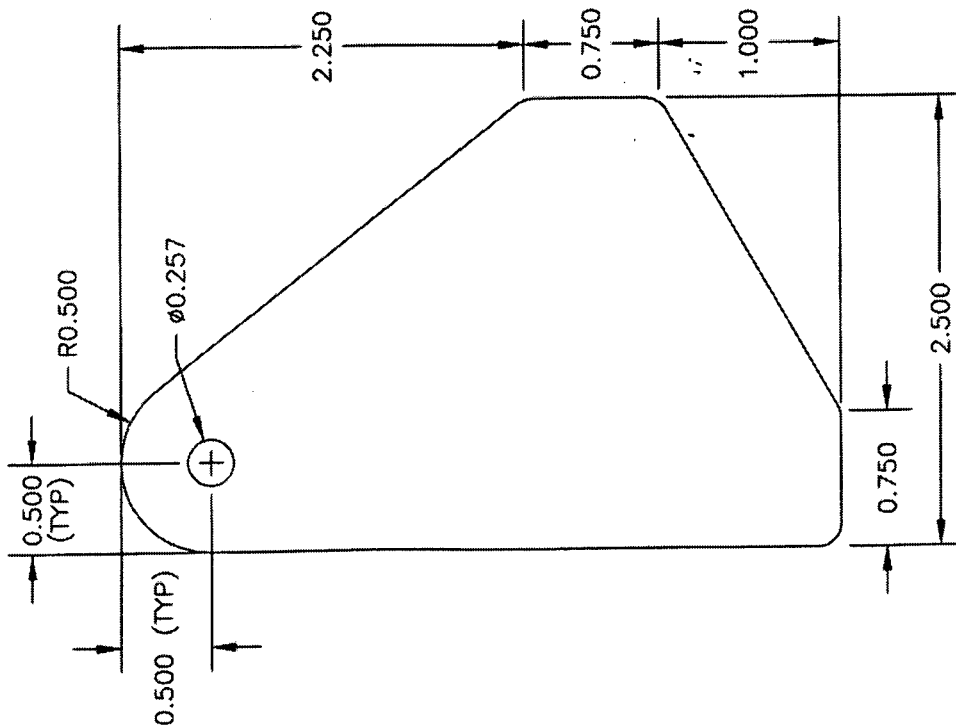
DESIGN	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ME</i>	APPROVED <i>KE</i>	DRAWING NO. D2232	REV. C SHEET 1 OF 2
DATE 98.04.28	TITLE BASKET HINGE		SCALE 1:1
A	94.05.12	NEW ISSUE	
B	96.01.02	ADDED -5 AND -7	
C	98.04.28	0.125 THICK WAS 0.063	

RELEASED
98.05.05 KE



D2232-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41755
2810-9-01



D2232-3

MATERIAL: AISI 304/316 SS 0.125 THICK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

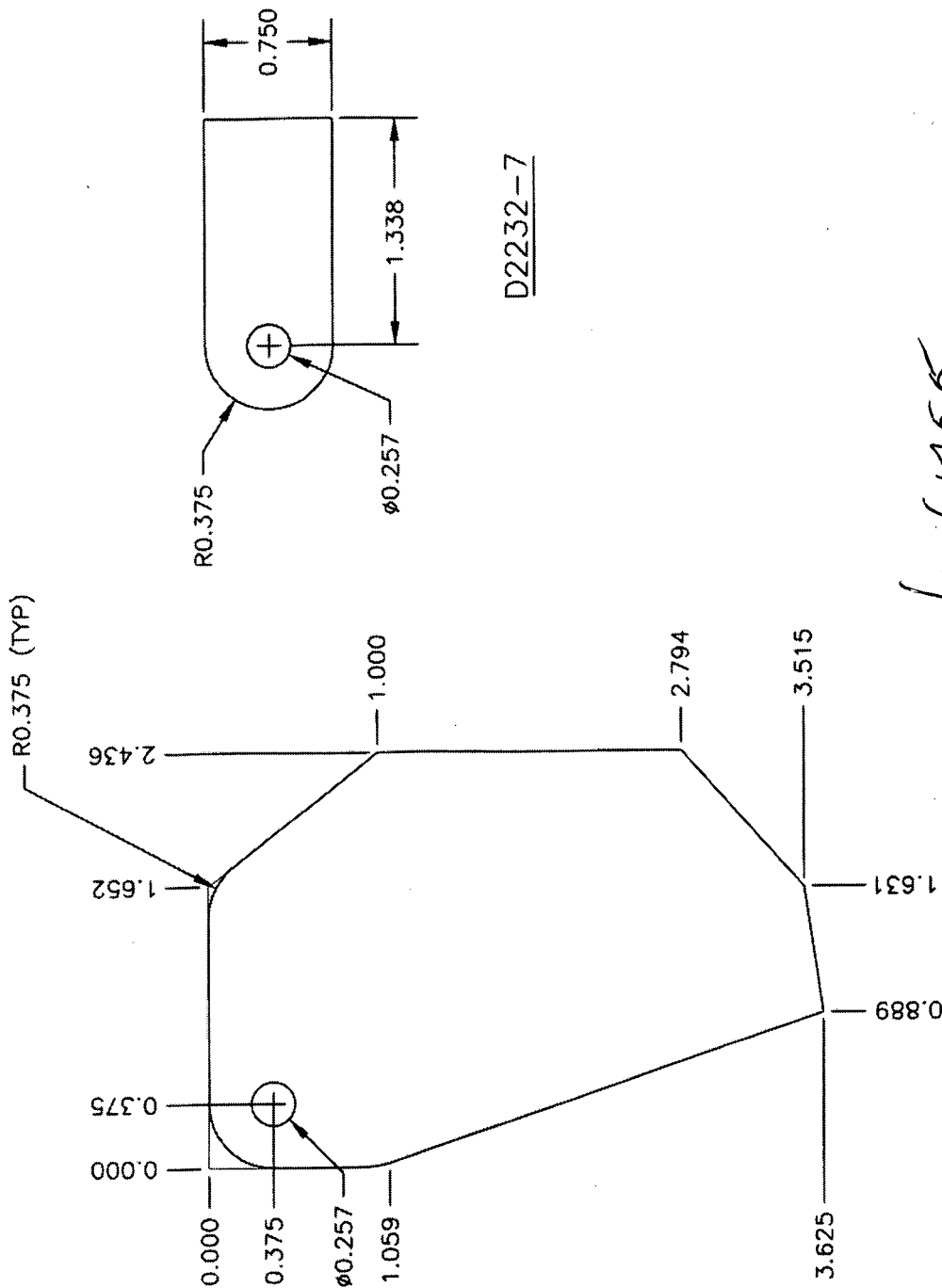
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NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2232	REV. C SHEET 2 OF 2
DATE 98.04.28		TITLE BASKET HINGE	SCALE 1:1

RELEASED
98.05.05 KE



D2232-7

W6 61755

D2232-5

MATERIAL: AISI 304/316 SS 0.125 THICK

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